



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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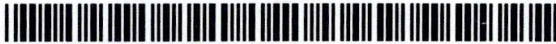
RBEA62310-01
Job Sheet 188423



Part No: RBEA62310-01

Job Qty: 10 pcs

Part Name: Top Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/9/19

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEA62310 Rev 1A IPP Rev A 18.01.17 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	10 pcs	1/31/19		0.00	10.00	Large Fab - 1		JBL
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
120	QC 9	10 pcs	1/31/19		0.00	0.00	QC 9 - 10		AL
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	Powdercoat - 13 Yellow - B4B	10 pcs	1/31/19		0.00	1.00	Powdercoat - 1 - B4B		BEB 19-02-27
							Powdercoat - 2 - B4B		
							Powdercoat - 3 - B4B		
							Powdercoat - 4 - B4B		
140	QC 3	10 pcs	1/31/19		0.00	0.00	QC 3 - 10		
							QC 3 - 13		
							QC 3 - 15		
							QC 3 - 17		
							QC 3 - 18		
							QC 3 - 2		
							QC 3 - 26		
							QC 3 - 28		
							QC 3 - 3		
							QC 3 - 30		
							QC 3 - 34		
							QC 3 - 36		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

150 Packaging 3-1 - Stock - B4B 10 1/31/19 0.00 0.00
pcs

QC 3 - 38	
QC 3 - 41	
QC 3 - 51	
QC 3 - 58	
QC 3 - 59	
QC 3 - 6	
QC 3 - 68	
QC 3 - 9	

sc 1902/27

DAS
28
9-89

Packaging 3 - 1 - B4B
Packaging 3 - 2 - B4B
Packaging 3 - 3 - B4B
Packaging 3 - 4 - B4B
Packaging 3 - 5 - B4B
Packaging 3 - 6 - B4B
Packaging 3 - 7 - B4B
Packaging 3 - 8 - B4B
Packaging 3 - 9 - B4B
Packaging 3 - 10 - B4B
Packaging 3 - 11 - B4B
Packaging 3 - 12 - B4B
Packaging 3 - 13 - B4B
Packaging 3 - 14 - B4B
Packaging 3 - 15 - B4B
Packaging 3 - 16 - B4B
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Packaging 3 - 28 - B4B
Packaging 3 - 29 - B4B
Packaging 3 - 30 - B4B
Packaging 3 - 31 - B4B
Packaging 3 - 32 - B4B
Packaging 3 - 33 - B4B
Packaging 3 - 34 - B4B
Packaging 3 - 35 - B4B
Packaging 3 - 36 - B4B

DAS
28
9-89

160 QC 21 - SA 10 1/31/19 0.00 0.00
pcs

QC 21 - SA - 21
QC 21 - SA - 70

DAS
21 MAR 01 2019
9-89

Part Op 110 - (Weld per dwg A/R Steel rod Batch: _____), Weld as per DWG
 Descriptions: 120 - (QC9- Inspect visual per QSI004- Fusion Welds)
 130 - (Powdercoat13 - Yellow #13538), Mask threads before painting
 140 - (QC3- Inspect Part Finish)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
98750A017	RH All Thread	10 pcs (1 ea)	110-Large Fab - Welded Assy-1	
RBEA62310-03	Top Plate	10 pcs (1 ea)	110-Large Fab - Welded Assy-1	

S/22592
S/105255

change to WARB-01

Job Allocations

Process 10 ring

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	98750A017	10	15	0
	RBEA62310-03	10	36	0
Part Specifications				
Specifications could not be found.				

Plex 1/9/19 1:03 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

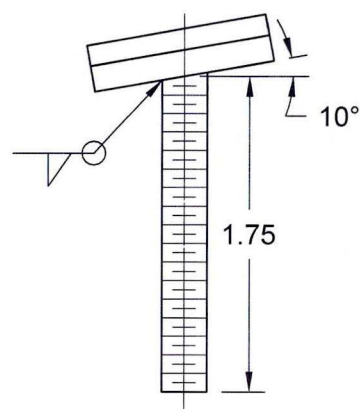
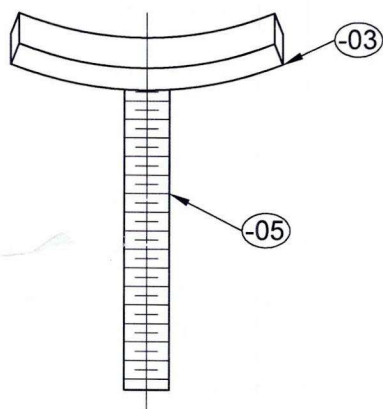
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		OTHER : ☐			

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
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(-01)
TOP
WELDMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 188423 HWS
1901-10

NOTES:

1. MASK THREADS BEFORE PAINTING.

RED BARN MACHINE	
TITLE AS350/355 ENGINE STRUT	
DWG NO. RBEA62310-01	REV 1A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 METRIC REF. .XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED: <i>D. Weid</i> HEAT TREAT FINISH PRIME & PAINT YELLOW SPEC USED ON MODEL EUROCOPTER AS350 & AS355
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 3-10-10 SHEET 2 of 7

DART
AEROSPACE

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Haykesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S149117



Part: RBEA62310-01

Job No: 188423

Serial No/Batch: S149117

Revision: 1A

Inspector:

Exp Date:

Instructions:

Date: 01/29/19